

Date: Friday, 8/3/2007 10:03:29 AM
 User: Eric Charbonneau

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STA 129 BRACKET
Job Number : 33602	
Estimate Number : 11643	
P.O. Number :	Part Number : D29902
This Issue : 8/3/2007 S.O. No. :	Drawing Number : D2990 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : 7/17/2007 Type : SMALL /MED FAB	Drawing Revision : B
Previous Run :	Material :
Written By : <u>EC 07.08.03</u>	Due Date : 8/10/2007 Qty: 7 Um: Each
Checked & Approved By :	
Comment : Est. A 01.31.01 New Issue EC	
est B 07.08.03 waterjet blank EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6B0500X12000	6061-T6 Bar .50" x 12.0"
-----	--------------------	--------------------------



Comment: Qty.: 0.9913 f(s)/Unit Total : 6.9391 f(s)

6061-T6 Bar .50" x 12.0"

Material: 6061-T6 bar 12.00" x 0.50"

Batch: M102 508

SAH 07/08/03

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per template DT8547 ****(prog. DT8547)****

Dwg Rev: NA

Prog Rev: NA

2-Deburr if necessary

SAH 07/08/03

(7)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio FA107

SAH 07/08/12

(7)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAH 07/08/12

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

SAH 07.08.13

(7)

Date: Friday, 8/3/2007 10:03:29 AM
User: Eric Charbonneau

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STA 129 BRACKET

Job Number: 33602

Part Number: D29902

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Tumble & Deburr

SE 07/08/13

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

36 07-08-14 (7)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

BR/mip 07-08-15

(7)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

EP 07/08/16 (7)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07-08-17

Job Completion



u 07-08-16

DART AEROSPACE LTD		Work Order:	<u>33602</u>
Description: STA 129 Bracket		Part Number:	D2990-2
Inspection Dwg: D2990 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

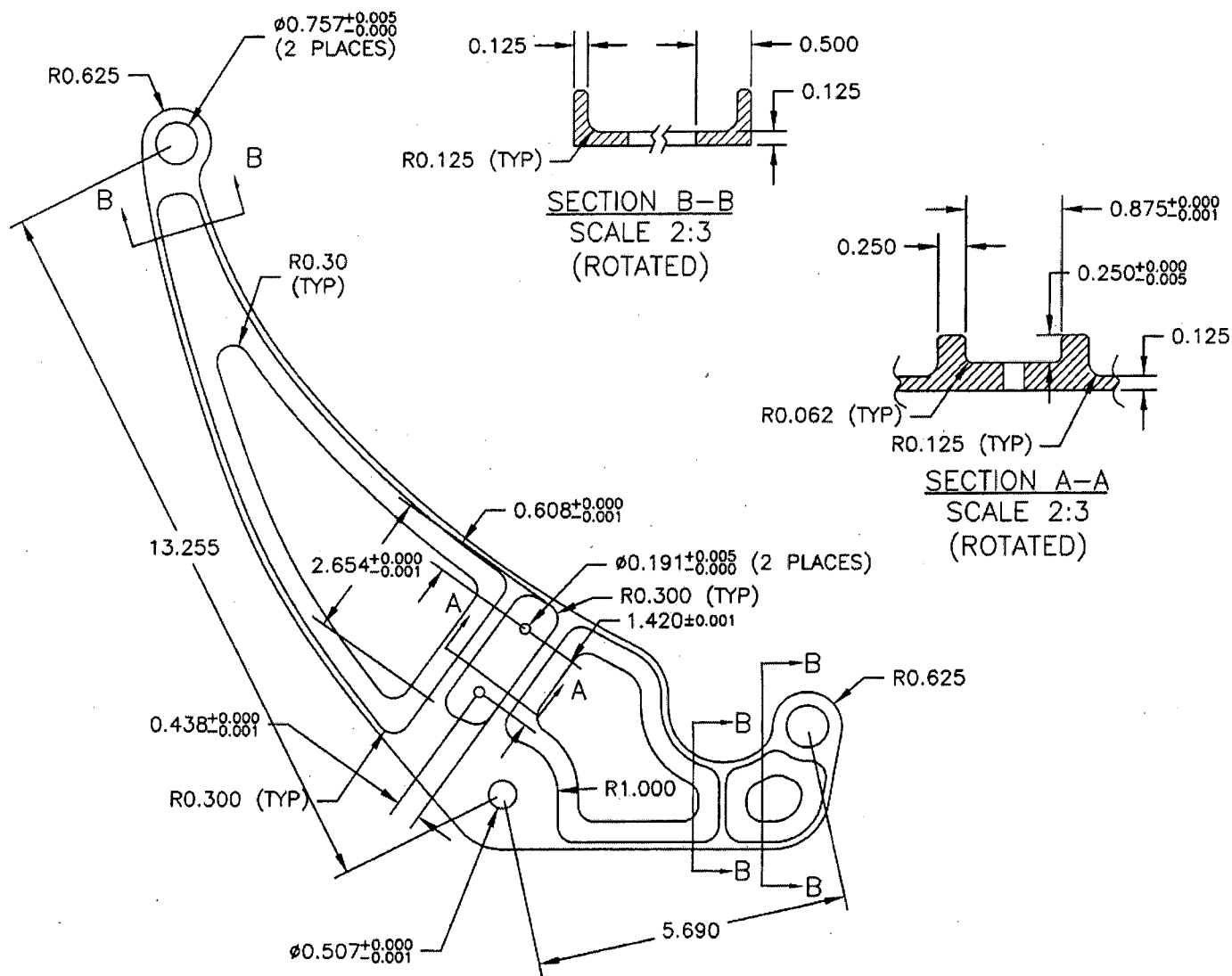
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.757	+0.005/-0.000	.757	✓			
0.438	+0.000/-0.001	.438				
Ø0.507	+0.000/-0.001	.5065				
5.690	+/-0.005	5.685				
R1.000	+/-0.010	1.000				
1.420	+/-0.001	1.4205				
Ø0.191	+0.005/-0.000	.1915				
0.608	+0.000/-0.001	.608				
2.654	+0.000/-0.001	2.654				can't measure this.
0.125	+/-0.010	.126				
R0.062	+/-0.010	.0620				
0.125	+/-0.010	.125				
0.250	+/-0.010	.250				
R0.125	+/-0.010	.125				
0.250	+0.000/-0.005	.248				
0.875	+0.000/-0.001	.8745				

Measured by: <u>JB</u>	Audited by: <u>SD</u>	Prototype Approval:	N/A
Date: <u>07/08/12</u>	Date: <u>01.08.12</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue	KJ/RF	
B	06.03.08	Dwg Rev. change	KJ/JLM	

DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD	
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	REV. B
				D2990	SHEET 1 OF 2
DATE	05.01.20	TITLE	STA 129 BRACKET	SCALE	1:3
A	00.11.07	NEW ISSUE			
B	05.01.20	ADD CUTOUTS & -043/-044			

RELEASED05.03.11 *[Signature]***D2990-1 BRACKET (SHOWN). D2990-2 BRACKET (OPPOSITE)**

- 1) MACHINE PER DRAWING FILE "D2990.SLDPR1"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERINGUNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICEWORK ORDER
NO. **33602**

Copyright © 2000 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

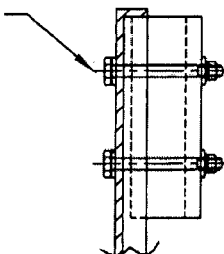


DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2990	REV. B SHEET 2 OF 2
DATE 05.01.21	TITLE STA 129 BRACKET		SCALE 1:3

RELEASED

05.03.11 #

AN3C16A BOLT (1)
NAS1515H3 WASHER (2)
MS21043-3 NUT (1)
INSTALL BOLT WITH LPS-3 CORROSION
INHIBITOR (ENSURE NO LPS-3 ON THREADS)
(2 PLACES)



USE D2990-1 FOR D2990-041/-043
USE D2990-2 FOR D2990-042/-044

SECTION C-C
SCALE 1:3
(ROTATED)

USE D2805-1 FOR D2990-041
USE D2805-2 FOR D2990-042
USE D2805-3 FOR D2990-043
USE D2805-4 FOR D2990-044
PRESS INTO PLACE PRIOR TO POWDER COAT

D2990-041/-043 BRACKET ASS'Y (SHOWN).
D2990-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 33602

Copyright © 2000 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.